

Work Order ID 52858

October 15, 2009 2:47:22 PM

Page 1

*Right hand*

Item ID: D206-642-251

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *09-10-15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

M

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-251

CHG001

*N/A**Right*

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Item ID: D206-642-251

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐ M109213/M111999

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

> DP9-10-19

3 BE 0910-21

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

BE 09/10/21

120

QC6- Inspect dimensions to drawing

0.00

27 50/10/21

0.00

Memo



QC

Quality Control

(X) f

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Customer:

Reference: •

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

1 M 9-10-23

Skidtubes

Memo

0.00

Skidtubes

1-Open crossbolt holes to Ø0.3125"

2- Open Aft cap hole #6.

****no wearplate holes for this skidtube****

3-Deburr tube and blow out chips from inside the tube

140

0.00



Chemical Conversion Coat per QSI005 4.1

1 M 9-10-23

HandFinish

Memo

0.00

Hand Finishing

150

0.00



QC3- Inspect Part Finish

2) 801/11/23

QC

Memo

0.00

Quality Control

20 /

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Skidtubes	0.00				1		9-10-23	
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								
170 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

2) 802/10/23



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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

0.00



Skidtubes

1 11/10/26 (PK) →

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☐ 9/10/26 ☐ Time: ☐ 10:15 ☐

Finish Date: ☐ 9/10/27 ☐ Time: ☐ 8:45am

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☐ M123A ☐

Sikaflex expire date: ☐ 0/2/30

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control


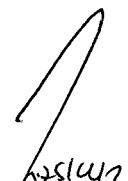

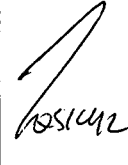
2) 8/10/27

(PK) 9

W/O: 52858		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
9/10/23	#150	<p>Peron. Change</p> <p>- Stock web missing holes for run on wear plates</p> <p>1- to be drilled before installing in skin tube</p> <p>2- to align for QST005</p>	9/10/23	NCR ↓ F			S 09/10/23	

Part No: D206-642-251 PAR #: _____ Fault Category: Skid tubes NCR: Yes No DQA: _____ Date: 05-11-25

Resolution: re-work Disposition: re-work QA: N/C Closed Date: 05-11-25

NCR: 52858		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-10-23	100	<p>Stock webs were missing holes.</p> <p>Not done on w/o 4867A</p> <p>Missed at inspection on that w/o</p> <p>R.C.: LOA</p>		<p>Drill holes in web before installing in skin tube</p> <p>- Re-align per QST005</p>	<p>9/10/23</p>	<p>S</p> <p>07/10/23</p>		<p>S</p> <p>09/10/23</p>
				<p>See W/O's 52855 & 52856 w/ the same issue.</p>				

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

BE 09/10/27

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐ m12507

BE 09/10/27

3-Grind welds flush as per Dwg D3804.

- AUM 9-10-28

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐ NONE

BE 09/10/28

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

- AUM 9-10-28

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Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Pressure Wash per QSI005 4.3	0.00	MD 09/11/02			X1			
	HandFinish	0.00							
	Hand Finishing								
	Memo								
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00	BL 09-11-2			①			
	Powdercoat	0.00							
	Powder Coating								
	Memo								
	START TIME: 3:20								
	OVEN TEMPERATURE: 300								
	FINISH TIME: 3:50								
260	QC3- Inspect Part Finish	0.00	MD 09/11/05			X1			
	QC	0.00							
	Quality Control								
	Memo								

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Item ID: D206-642-251

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Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinishing

MD09/11/05

X1

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

280

0.00



HandFinishing

X1

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/R ☐ Sikaflex-291 ☐ M11239 ☐
Sikaflex expire date: ☐ 10/20

MD09/11/05

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: M112106

BR 09-11-5

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Revision ID: M

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Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	Handwritten: 2d 09/11/05			Handwritten: (VI) 0			
300 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Handwritten: 3d 09/11/05			Handwritten: (40) 0			
310 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-251 Location: _____ PPP Rev: _____	0.00 0.00				Handwritten: 10/11/05 (U)			

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Item ID: D206-642-251

Accept



Setup Start



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Stop



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Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
320	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/06 *[Signature]*

MF

09-11-05

Picklist Print

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Page 1

Work Order ID: 52858

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB		Manufactured	No			110	Each	19.0000	1.0000			

Skidtube, 206 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

45898

19

D3286-1RevA

Manufactured

No

110

Each

27.0000

2.0000



Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

44286

1

46440

6

47692

20

D2647RevF

Manufactured

No

110

Each

27.0000

1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

10773

7

43846

20

29-10-19

1

2 BE 09/10/20

1 BE 09/10/20

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Work Order ID: 52858



Parent Item: D206-642-251RevA



Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-04		Purchased	No			180	Each	704.0000	52.0000			
Cherry Rivet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	704	
109297	26	
109740	16	
110153	6	
111127	78	
112314	378	
112612	200	

57 11/9/10/26

D2654-3RevE1

Manufactured No

180

Each

10.0000

1.0000



Web

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
48679	10	

1 11/9/10/26

Picklist Print

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Work Order ID: 52858

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			200	Each	617.0000	20.0000			



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	534	
36013	5	
47112	383	
48271	146	

D3286-3RevA

Manufactured No



Spacer

200 Each 43.0000 2.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	43	
35048	1	
41900	1	
43862	1	
46643	40	

20

BE 09/10/27

2

BE 09/10/28

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Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CCR264SS3-3		Purchased	No			210	Each	267.0000	2.0000			

Cherry Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	267	
111548	52	
111827	115	
112314	100	

CR3212-4-03

Purchased

No

210

Each

310.0000

2.0000

Cherry Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	310	
111359	96	
112314	200	
15984	14	

AWM 9-10-26 (2)

M110139 AWM 7-10-28 (2)

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Work Order ID: 52858

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2680-041RevB1		Manufactured	No			210	Each	79.0000	1.0000			

Nut Plate

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

79

33061

14

44086

65

D3805-043RevA

Manufactured

No

270

Each

0.0000

1.0000

Wearplate Assembly Fwd, High Gear

D3805-047RevA

Manufactured

No

270

Each

0.0000

1.0000

Wearplate Assembly Aft, High Gear

AN3-37A

Purchased

No

270

Each

773.0000

7.0000

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

773

105425

273

111668

500

AWM 9-10-27 (1)

X1 mo 09/11/05

X1 mo 09/11/05

X1 mo 09/11/05

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Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

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Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960C10L

Purchased

No

270

Each

4,446.000 7.0000



washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

4346

112116

993

112612

3353

X7 MD 09/11/05

MS21042L3

Purchased

No

270

Each

3,503.000 7.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3503

110844

32

111274

41

111668

930

112314

2000

112385

500

X7 MD 09/11/05

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Work Order ID: 52858



Parent Item: D206-642-251RevA



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Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3873-1RevA

Manufactured

No

270

Each

73.0000

14.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

28

46757

6

48267

22

Main Warehouse

ST139

45

50479

45

X 14

MO 09/11/05

AN960JD10L

Purchased

No

270

Each

5,969.000 2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5969

101291

16

104885

153

105793

236

109632

564

110985

5000

X 12

MO 09/11/05

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Work Order ID: 52858

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08		Purchased	No			270	Each	3,035.000	2.0000			

Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3035	
110467	192	
110552	843	
110835	2000	

X2 MD 09/11/05

D2651-1RevB

Manufactured No



Plug

270 Each 403.0000 8.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	403	
43990	125	
45490	28	
51530	250	

X8 MD 09/11/05

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Work Order ID: 52858



Parent Item: D206-642-251RevA



Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-3RevB		Manufactured	No			270	Each	1,035.000	8.0000			
O-Ring												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1035

43849

3

46114

1032

270

Each

77.0000

1.0000

MS27039-4-06

Purchased

No



Screw

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

77

109061

77

X8 mo 09/11/05

X1 mo 09/11/05

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Work Order ID: 52858



Parent Item: D206-642-251RevA



Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			270	Each	5,441.000	1.0000			

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5441	
102929	2	
105906	4	
106277	2	
107321	23	
107939	114	
108161	521	
108827	31	
109249	69	
110523	340	
111279	101	
111916	482	
112314	3752	
16941	0	

VI MD 09/11/06

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Work Order ID: 52858



Parent Item: D206-642-251RevA



Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC		Manufactured	No			280	Each	53.0000	1.0000			

Aft Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	53	
20208	0	
43801	1	
46327	4	
48109	48	

XL mo 9/11/05

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

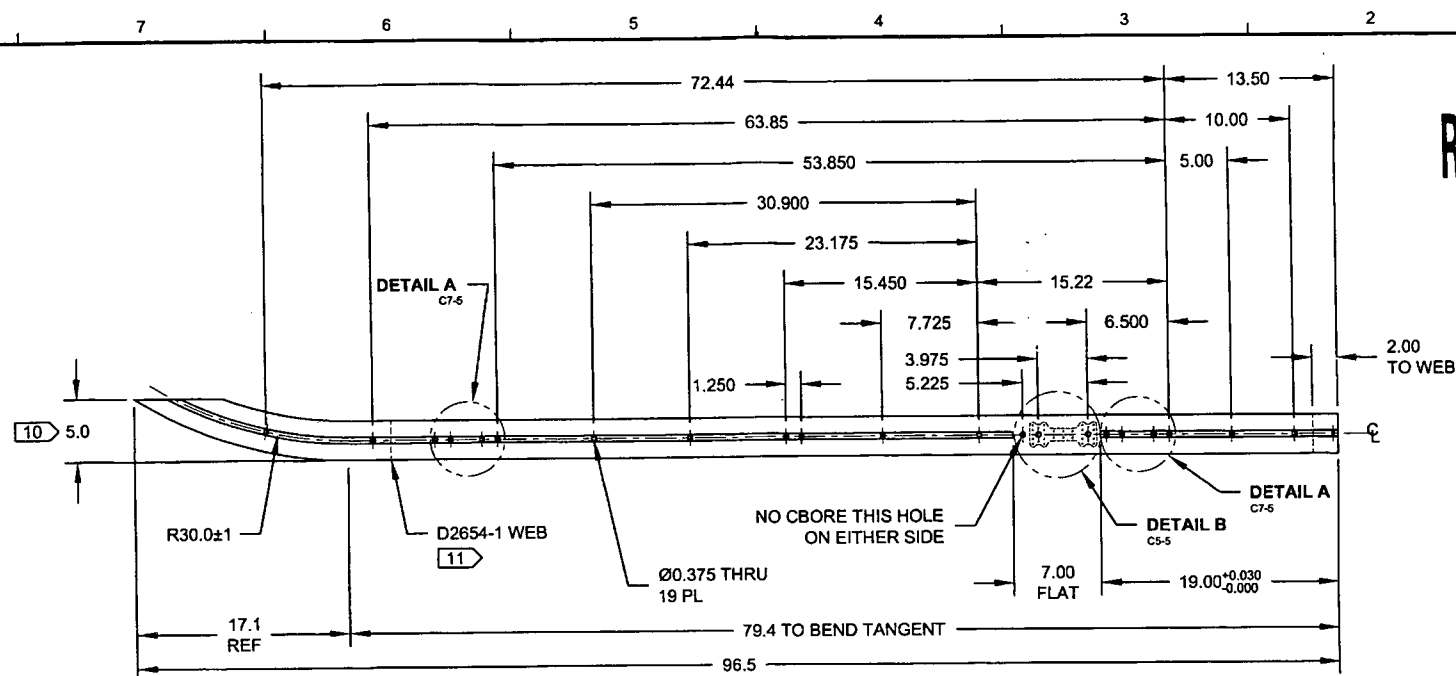
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CP 09-07-03
PC ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>91</u>		
DRAWN	<u>1</u>		
CHECKED	<u>91</u>		
MFG. APPR.	<u>91</u>		
APPROVED	<u>91</u>		
DE APPR.	<u>91</u>		
DATE	08.07.07		

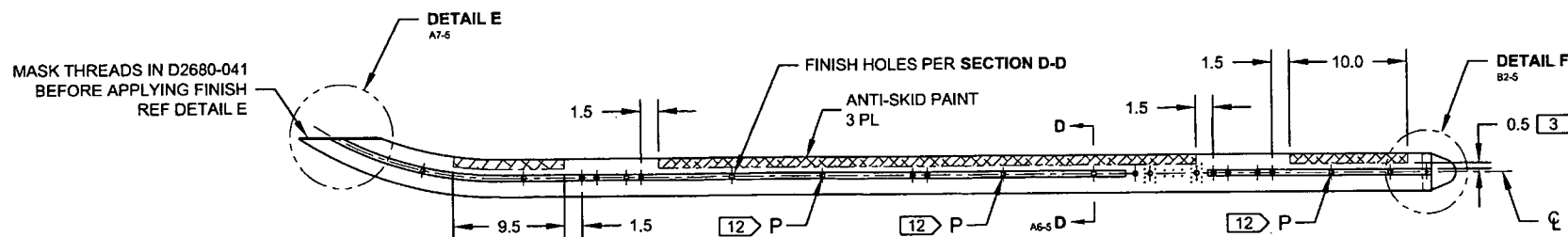
DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS

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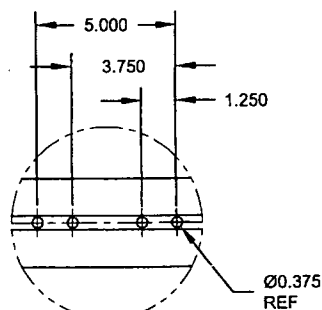
D3804-041 BENDING/DRILLING DETAIL



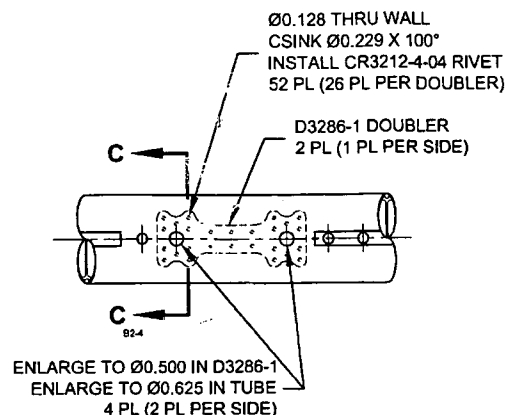
D3804-041 ASSEMBLY/FINISHING DETAIL

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CHECKED	φ	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 2 OF 5
APPROVED	19	TITLE	SCALE
DE APPR.	11	SKIDTUBE ASSEMBLY, 206A/B	NTS
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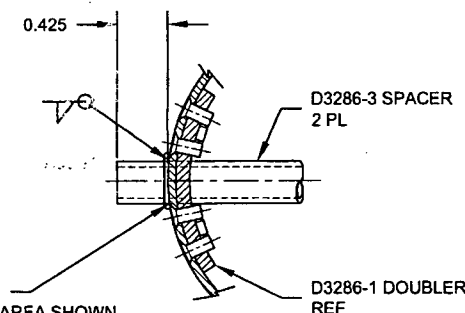
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DETAIL A
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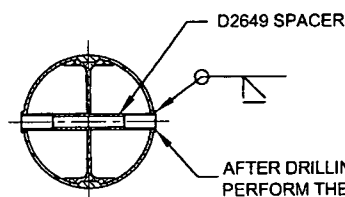


DETAIL B
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORER TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

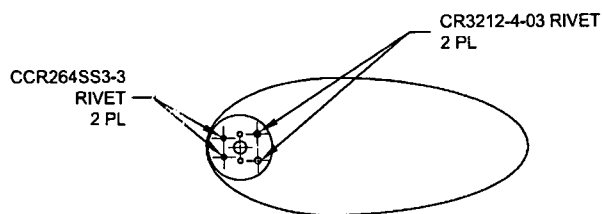
SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE

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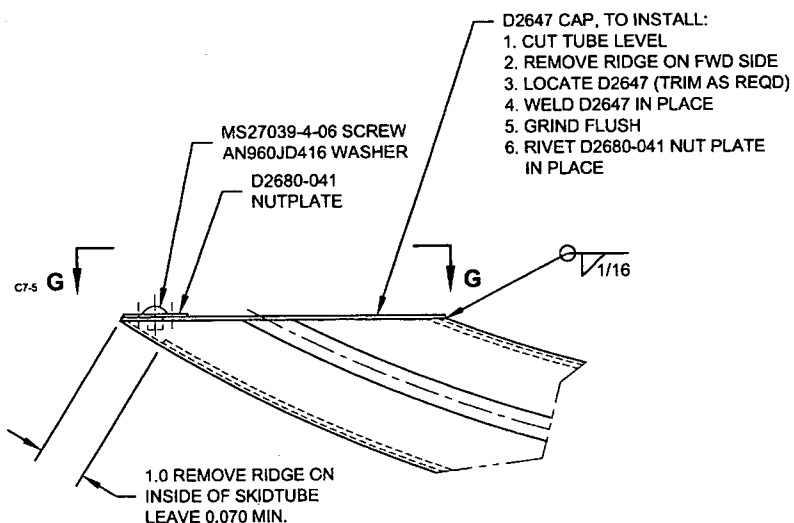
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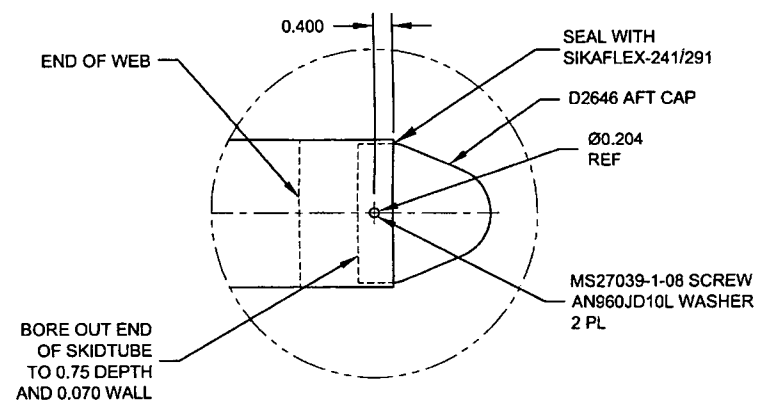
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VIEW G-G
SCALE NONE A7.5



DETAIL E
SCALE NONE B7.2 B7.3



DETAIL F
SCALE NONE B2.2 B2.3

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MFG. APPR.	91	D3804	SHEET 5 OF 5
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NO. 214

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52855
Part number: D206-642-251
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base materiel: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Daniel Date of Test Coupon 09.10.29
Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld